

Work Order ID 72234

Wednesday, July 20, 2011 9:06:46 AM



Page 1

Item ID: D3260-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Spring

50

Start Date: 7/20/2011

Start Qty: 30.00



Cust Item ID:

Required Date: 7/27/2011

Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/07/20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3260

Rev A

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 15535 ☐ Make as per Dwg D3260 ☐ Possible Supplier:
Victory Spring ☐ Material release note is required

CL 11/07/20 (50)

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

Pu/p/28 (50)

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

11 07 28 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72234

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Wednesday, July 20, 2011 9:06:46 AM

Item ID: D3260-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Spring

Start Date: 7/20/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 7/27/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 44

0.00



Packaging

Memo

0.00

Packaging

11/7/28 (50) SP

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/29 (50) SP11-07-28 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 20, 2011 9:06:44 AM

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Work Order ID: 72234



Parent Item: D3260-1



Parent Item Name: Spring


Start Date: 7/20/2011

Required Date: 7/27/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP A 04.03.29 New issue KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3260-1P  Spring		Purchased	No			100	Each	0.0000	1	30		7/27/11	50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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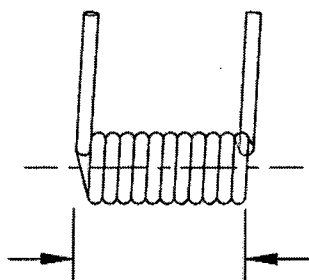
NOTE: Date & initial all entries



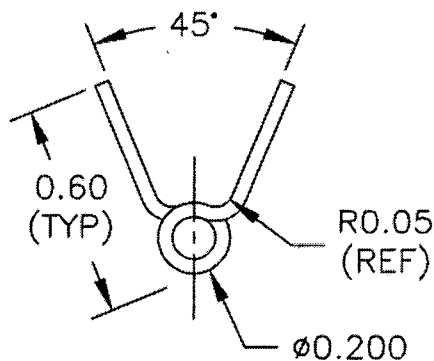
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3260	REV. A SHEET 1 OF 1
DATE 04.02.27		TITLE SPRING	SCALE 2:1
A	04.02.27	NEW ISSUE	

RELEASED
04.04.07

SPECIFICATION CONTROL DRAWING



$\phi 0.040$
12 COIL
(REF 0.480)



D3260-1 SPRING

CL11/07/20

W10.72234

D3260-1 NOTES:

- 1) MATERIAL: AISI 302 SS SPRING WIRE $\phi 0.040$ PER ASTM A313
(MIN TENSILE STRENGTH = 250 ksi)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



convenient. consistent. correct.

PACKING SLIP

22894

#2, 6104 - 82 Ave
Edmonton, AB T6B 0E7
t + 780 442 4020
f + 780 466 8000

BILL TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawkesbury ON K6A 1K7

SHIP TO:

DATE		ORDER No.		SHIP VIA	
27-Jul-11		14453 / 14535		Puro Express ppd & chrg	
QUANTITY	DESCRIPTION			UNIT	AMOUNT
30	D3260-1P Spring				
50	D3260-1P Spring				
GST #	TERMS	SUBTOTAL	FREIGHT	GST	TOTAL
854454527	NET 30 DAYS				

CERTIFICATE OF CONFORMANCE

REPORT FOR : Dart Aerospace Ltd	DATE: 7/27/2011
PART/DRAWING #: D32601P	PO # 14453 / 14535
SPRING DESCRIPTION: Torsion	QUANTITY: 30 + 50

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS 302	yes	
Material diameter	0.04	0.04	
Coil I.D.			
Coil O.D.	0.200	0.199	
Number of Coils	12	12	
Free Length	0.480 ref	0.477	
Helix	LHW	yes	
End type	legs as per dwg	yes	
Deburr End			

COMMENTS

Full Certificate attached:

Material Heat Number:

Inspected by:

Chris Burrowes